

Reesh shp 24-25/4

Work Order ID 64012

November 23, 2010 7:03:21 AM



Page 1

Item ID: D3199-4

Revision ID:

Item Name: Bracket, Fwd RH

Start Date: 11/24/10 Start Qty: 8.00

Required Date: 11/25/10 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: *W*
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr	Revision Nbr
D3199	C

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

304 . 040

Cut as per Dwg D3199

Dwg Rev: *C*

Prog Rev: *C*

Deburr if required

1810-11-23

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

1810-11-23

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64012

November 23, 2010 7:03:22 AM

Page 2

Item ID: D3199-4

Accept

Revision ID:

Item Name: Bracket, Fwd RH

Setup Start

Stop

Start Date: 11/24/10 Start Qty: 8.00

Required Date: 11/25/10 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

Sp 10/16/23

(x8)

130



Brake NC

Brake NC

Bend as per dwg
Small Fab

Memo

0.00

0.00

Sp 10/16/23

(8)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Sp 10/16/23

(8)

-7's

W/O:		WORK ORDER CHANGES					
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Work Order ID 64012

November 23, 2010 7:03:22 AM

Page 3

Item ID: D3199-4

Revision ID:

Item Name: Bracket, Fwd RH

Start Date: 11/24/10 Start Qty: 8.00

Required Date: 11/25/10 Req'd Qty: 8.00

Reference:

Approvals:

Process Plan:

Date:

QC:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

0.00

Memo

START TIME: 8:00am
OVEN TEMPERATURE: 320°F
FINISH TIME: 8:30pm

741011121

8. d

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

11/24/24 (8K) SP

170



Packaging

Packaging

Identify as per dwg & Stock Location:

500

0.00

0.00

Memo

11/24/24 8K SP

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 64012

November 23, 2010 7:03:23 AM



Page 4

Item ID: D3199-4

Accept



Setup Start



Revision ID:

Item Name: Bracket, Fwd RH

Stop



Start Date: 11/24/10 Start Qty: 8.00



Cust Item ID:

Required Date: 11/25/10 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/11/24
MF
10-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 23, 2010 7:03:12 AM

Page 1

Work Order ID: 64012

Parent Item: D3199-4

Parent Item Name: Bracket, Fwd RH



Start Date: 11/24/10

Required Date: 11/25/10

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: RevC-prelim DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S20GA

Purchased

No

100

sf

96.2000

0.3371

2.838737



304/316 .040 Sheet



1810-11-23

Location

Loc Qty

Loc Code

MAT

92.2

115762

10.2

115953

82

MAT20

4

113062

1.398

115440

2.602

115953

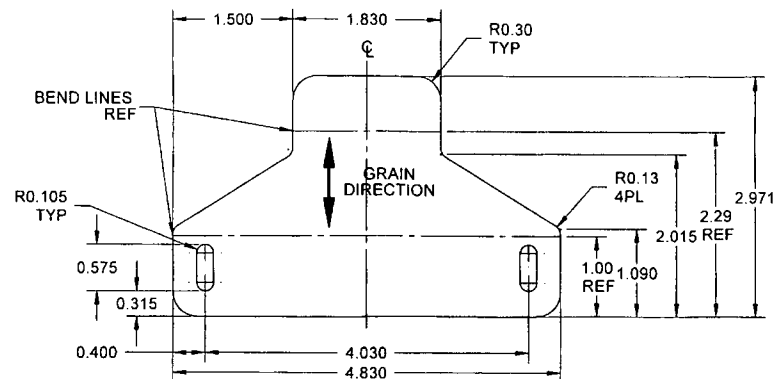
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

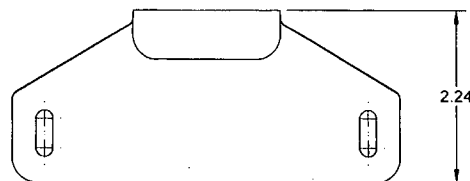
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

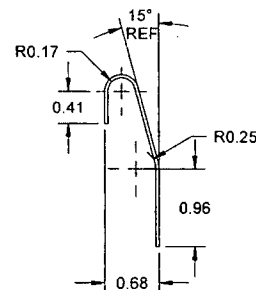
NOTE: Date & initial all entries



D3199-1F FLAT PATTERN



D3199-1 BRACKET
MADE FROM D3199-1F



RELEASED
2009-11-20

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs

C	ADD -3/4 PART (SHEET 2-4)	CB	09.11.19
B	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	CB	06.11.01
A	NEW ISSUE	CP	03.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN			
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D3199	SHEET 1 OF
APPROVED		TITLE	SCALE
DE APPR.	BRACKET	NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

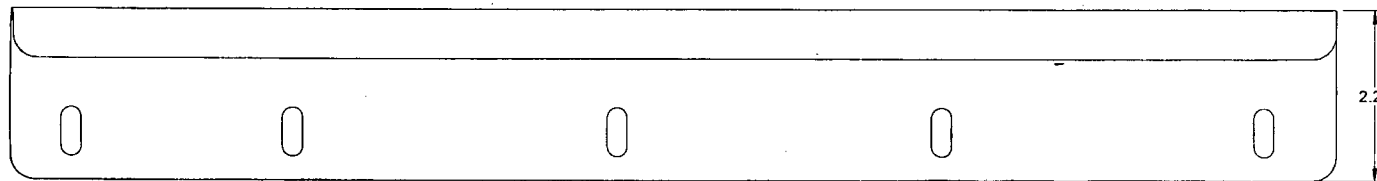
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

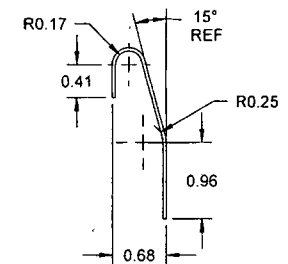
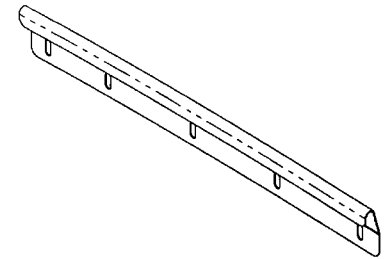
NOTE: Date & initial all entries




0.14



2.24



 **D3199-3 BRACKET**
MADE FROM D3199-3F

do 6/10/02

RELEASED
2009-11-20
MP

NOTES:

- 1) MATERIAL: MADE FROM D3199-3F
- 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.55 lbs

DESIGN	<i>45</i>	DART AEROSPACE LTD	
DRAWN	<i>45</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>45</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>45</i>	D3199	SHEET 2 OF 4
APPROVED	<i>45</i>	TITLE	SCALE
DE APPR.	<i>45</i>	BRACKET	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

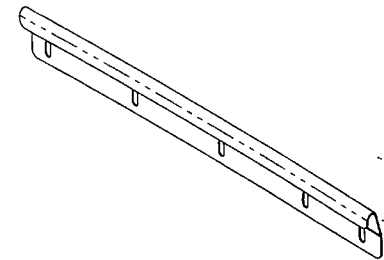
C

B

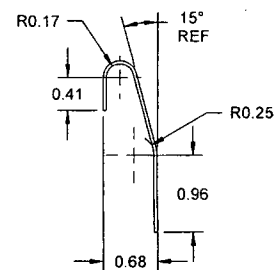
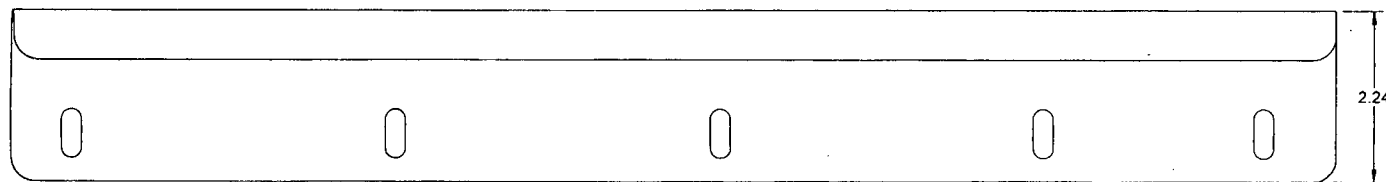
B

A

A



0.14



D3199-4 BRACKET
MADE FROM D3199-3F

W/O 64012

RELEASED
2009-11-20

- NOTES:**
- 1) MATERIAL: MADE FROM D3199-3F
 - 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-4" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.55 lbs

DESIGN		DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. D3199 REV. C
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE BRACKET SCALE NTS
DE APPR.		
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

